

Wednesday, November 24, 2010 3:56:23 PM

Page 1

Accept

**Setup Start**

stop

Start Date: 11/24/2010 **Start Qty:** 4.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-1-24

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

**Insp.
Stamp**

Revision Nbr

D3897

Rev B

0.00

100

[illegible]

Waterjet

FLOW CNC Waterjet

6061.050

Memo

0.00

1-Cut as per Dwg D3897

Dwg Rev:

Prog Rev:

grain direction per dwg

2-Deburr if necessary

0.00

QC2- Inspect parts off machine FAI/FAIB

110

Abstract

QC

Quality Control

Memo

0.00

B10-11-78

AB10-11-2A

W/O: 64122

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Perm. Change - update leader box to have also the correct information. Dwg 3897 Rev B	<i>[Signature]</i>	10.12.01			<i>[Signature]</i> 10/11/30

Part No: D3897-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64122

Wednesday, November 24, 2010 3:56:23 PM



Page 2

Item ID: D3897-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 11/24/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

8/10/130

XJ

Memo

0.00

130



Small Fab

Small Fab

Memo

1- Deburr if necessary

0.00

N/A

0.00

140



Brake NC

Brake NC

Memo

1- Bend as per dwg

0.00

Sp 10/1/30

0.00

S

Work Order ID 64122

Wednesday, November 24, 2010 3:56:23 PM



Page 3

Item ID: D3897-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 11/24/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 10/14/30



160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10/14/30



170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

5 10/14/30

Work Order ID 64122

Page 4

Wednesday, November 24, 2010 3:56:23 PM

Item ID: D3897-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 11/24/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

Identify as per dwg & Stock Location: 92

0.00

Memo

0.00

Packaging

10/11/30 [Signature]

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/01 [Signature]
10-11-30 (5)

Picklist Print

Wednesday, November 24, 2010 3:56:27 PM

Page 1

Work Order ID: 64122

Parent Item: D3897-1

Parent Item Name: angle





Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050 		Purchased	No			100	sf	199.5900	0.25	1.052632	1.3		
6061-T6 .050 Sheet											B10-1-09		

Location

Loc Qty

Loc Code

MAT

166.8

114799

38.8

114993

128

MAT21

32.79

110791

1.2

113216

31.59

110791

5

DART AEROSPACE LTD		Work Order:	64122
Description: Angle		Part Number:	D3897-1
Inspection Dwg: D3897 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.159	+0.005/-0.001	.161	X		VIB 02	
Ø0.204	+0.005/-0.001	.204	X		V	
0.425	+/-0.010	.425	X		V	
0.880	+/-0.010	.881	X		V	
Ø.239	+/-0.010	1.235	X		V	
0.50	+/-0.030	.502	X		V	
1.500	+/-0.010	1.499	X		V	
3.00	+/-0.030	3.000	X		V	
4.00	+/-0.030	4.000	X		V	
5.00	+/-0.030	5.000	X		V	
6.00	+/-0.030	6.022	X		V	
0.81	+/-0.030	.813	X		V	
2.94	+/-0.030	2.944	X		V	
5.10	+/-0.030	5.105	X		V	
5.85	+/-0.030	5.85	X		V	
0.75	+/-0.030	.750	X		V	
3.00	+/-0.030	3.005	X		V	
5.25	+/-0.030	5.252	X		V	
0.050	+/-0.010	.054	X		V	

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>10-11-29</u>	Date: <u>10/11/30</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.11.04	New Issue	KJ <u>[Signature]</u>	<u>[Signature]</u>

